

Work Order ID 81962

March-21-12 1:43:43 PM

AGAP
81962

Page 1

Item ID: D2230-3

Revision ID:

Item Name: Lug

Start Date: 21/03/2012 Start Qty: 200.00

Required Date: 04/04/2012 Req'd Qty: 200.00

Reference:

Approvals: Process Plan: MLJ
QC:

Date: 12/03/21 Tooling:
Date: SPC (Y/N):

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:
Customer:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr

Revision Nbr

D2230

Rev G

0.00

100

100

Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut D2423 extrusion to 0.82"

Batch:

0.00

Cut @ metec

0.00

110

110

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Machine per folio FA927

FOLIO REV:

DWG REV:

Check for crack while loading into the machine.

2- deburr

0.00

issue 10 to metec

machine as per dwg D 2230 REQ.G

PO 116535

12/03/22

Work Order ID 81962

March-21-12 1:43:43 PM

81962

Page 2

Item ID: D2230-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Lug
 Start Date: 21/03/2012 Start Qty: 200.00 *200* Cust Item ID:
 Required Date: 04/04/2012 Req'd Qty: 200.00 *200* Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120 *rec'd*
 120
 QC
 Quality Control

~~QC2- Inspect parts off machine FAI/FAIB~~

0.00

Memo

0.00

*rec'd + inspect
 attached cufc to w/d*

QC8- Inspect parts - second check

0.00

Memo

0.00

Scrubbing

130
 130
 QC
 Quality Control

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

150
 150
 HandFinish
 Hand Finishing

6/12/08 (70)

*cont
 470
 SP15*

(70) 7/6 12-5-8

Work Order ID 81962

March-21-12 1:43:43 PM

81962

Page 3

Item ID: D2230-3

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Lug

Start Date: 21/03/2012 Start Qty: 200.00

200

Cust Item ID:

Required Date: 04/04/2012 Req'd Qty: 200.00

200

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

70 φ 12-5-8

170

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

170

Powdercoat

Memo

0.00

Powder Coating

START TIME: 2:20

OVEN TEMPERATURE: 320 °F

FINISH TIME: 2:50

70X ✓ M-L 12/25/08

180

QC3- Inspect Part Finish

0.00

180

QC

Memo

0.00

Quality Control

70 φ 12-5-8

Work Order ID 81962

March-21-12 1:43:43 PM

81962

Page 4

Item ID: D2230-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Lug

Start Date: 21/03/2012 Start Qty: 200.00

200

Cust Item ID:

Req'd Date: 04/04/2012 Req'd Qty: 200.00

200

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

190

Identify as per dwg & Stock Location: *480*

0.00

190

Packaging

Memo

0.00

Packaging

70

*545
12/05/08*

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

12/5/9

ML5 12/05/09

Picklist Print

March-21-12 1:43:47 PM

Page 1

Work Order ID: 81962

81962

Parent Item: D2230-3

D2230-3

Parent Item Name: Lug

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 200.00

Required Qty: 200.00

Comments: IPP D00.05.18 Added inspection level 8. and removed P/O for powder coatEC
IPP REV :E NEW FOLIO # 10-05-25 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2230-3P		Purchased	No				Each	0.0000		200			
D2230-3P									**				
LUG													
D2423		Manufactured	No			100	f	307.3690	0.0683	14.37895			
D2423									**				
Lug Extrusion													

Location

Loc Qty

Loc Code

MAT006

307.369

43722

161.5

45800

1

68331

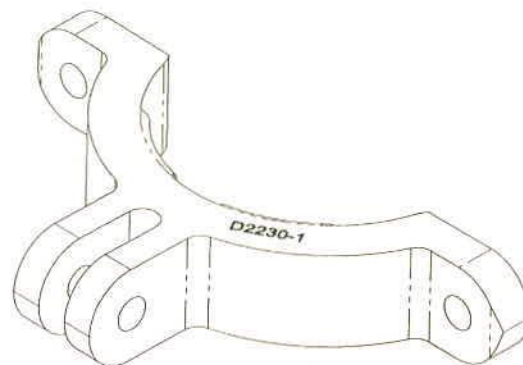
144.869

14.38

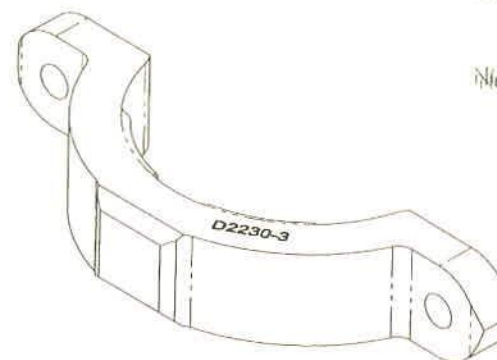
4/4/12 30
SP12-5-11

CL 12/03/23

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 81962 MJS
 12/03/21



D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

RELEASED
 07/06/25 MJS

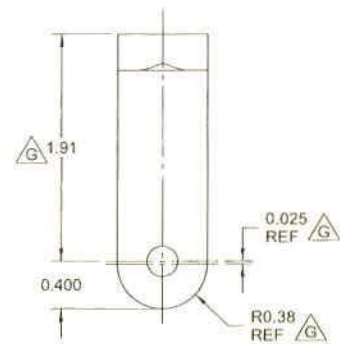
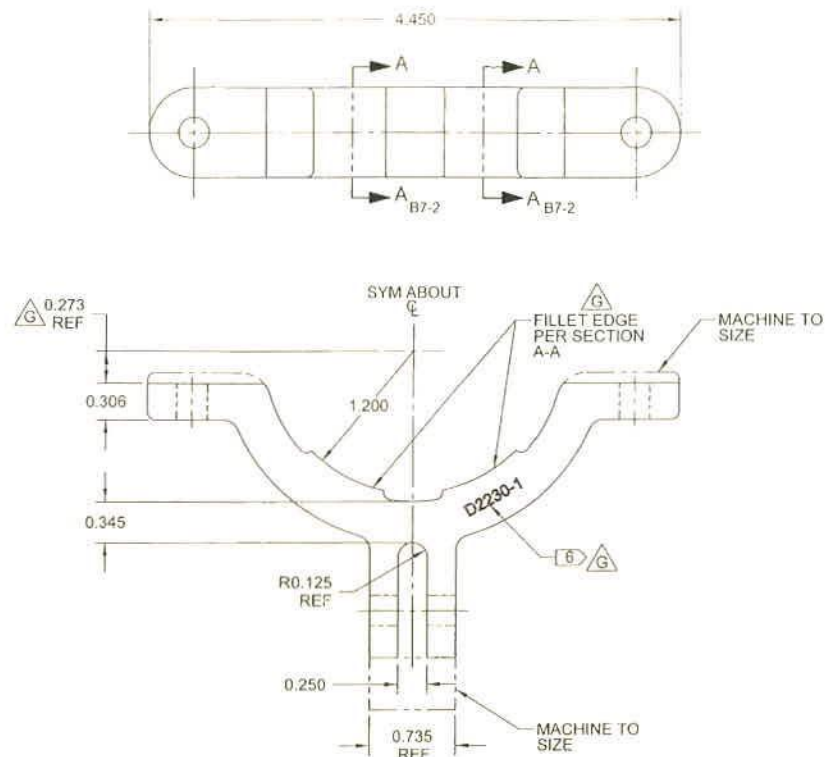
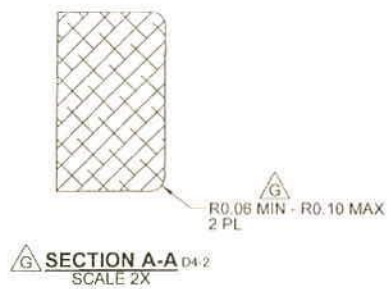


NOTES

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005
- 7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs

G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.16
F	REDESIGN: R1 200 WAS 1.100	CP	99.12.13
E	RE-DESIGN	BW	95.01.04
D	RE-DESIGN	BW	95.01.04
C	RE-DESIGN	BW	94.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.16	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS LOANED TO THE USER FOR THEIR USE ONLY. IT IS NOT TO BE USED FOR ANY PURPOSE OR COMING OR COMMUNICATED TO ANY OTHER PARTY WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

81962



D2230-1 MOUNTING LUG

RELEASED
09/06/25/17

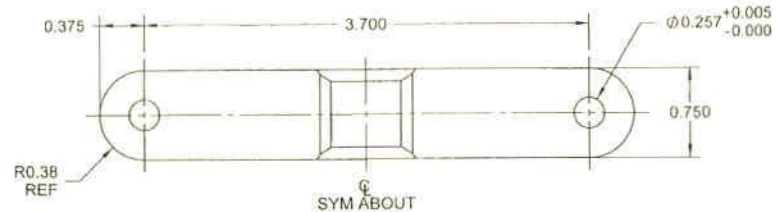
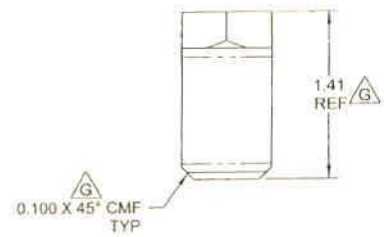
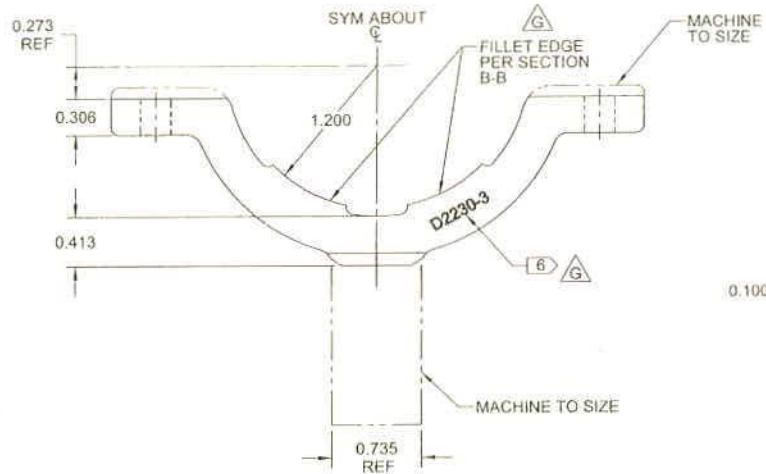
DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2230	REV. G
MFG. APPR		SHEET 2 OF 3	
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81962

SECTION B-B
SCALE 2X



R0.06 MIN - R0.10 MAX
2 PL



D2230-3 MOUNTING LUG

RELEASED
09/06/25

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
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60



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 18674
Date: May 08, 2012
Page: 1

Sold to:	Ship to:
Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: PO16535	Sold By: Dewar, Eric
Shipped By: your truck	Ship Date:

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D3235-1 Mounting Lug as per DWG: D3235 REV:A B81970	Each	100		
D2230-3 Mounting Lug as perDWG: D2230 REV:G B81962	Each	200	70	
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by _____		Thank you for your order!		



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0
Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
70	D2230-3	Lug <i>S. Walz</i>	16535

MATERIAL: supplied by DART B68331

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi Walz
Shigi Walz

Vankleek Hill, May 8, 2012